

# Work Order ID 86295

June-26-12 3:38:30 PM

**\*86295\***

Page 1

Item ID: D2330-043  
Revision ID:  
Item Name: Basket Lid Assembly

Accept

**\*N9000040100\***

Setup Start **\*NS1\***  
Stop **\*NS2\***

Start Date: 26/06/2012 Start Qty: 1.00 **\*1\***  
Required Date: 10/07/2012 Req'd Qty: 1.00 **\*1\***

Cust Item ID:  
Customer:

## Reference:

Approvals: Process Plan: MLJ Date: 12/06/20 Tooling: \_\_\_\_\_ Date: \_\_\_\_\_  
QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Run Start **\*NR1\***  
Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
<b>Draw Nbr</b>	<b>Revision Nbr</b>								
D2330	Rev H								
100		0.00							
<b>*100*</b>	Large Fab								
Large Fab	<b>Memo</b>	0.00							
Large Fab	1- Cut D2330-1-3-9 as per Dwg D2330 2-Drill hole in D2330-3 as per Dwg D2330 3-Deburr								
110		0.00							
<b>*110*</b>	Large Fab								
Large Fab	<b>Memo</b>	0.00							
Large Fab	1-Weld as per Dwg D2330 using Welding Table and corner Jig Deburr as required A/R SS ROD Batch: <u>M122B0</u>								
120		0.00							
<b>*120*</b>	QC9- Inspect visual per QSI004- Fusion Welds	0.00							
QC	<b>Memo</b>	0.00							
Quality Control									

DAS  
24  
8-83

12.10.15

1x

Ø

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Work Order ID 86295

**\*86295\***

Page 2

June-26-12 3:38:30 PM

Item ID: D2330-043

Accept

**\*N900040100\***

Setup Start **\*NS1\***

Revision ID:

Item Name: Basket Lid Assembly

Stop **\*NS2\***

Start Date: 26/06/2012 Start Qty: 1.00

**\*1\***

Cust Item ID:

Required Date: 10/07/2012 Req'd Qty: 1.00

**\*1\***

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start **\*NR1\***

QC:

Date:

SPC (Y/N):

Date:

Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

130

QC5- Inspect part completeness to step on W/O

0.00

**\*130\***

QC

Memo

0.00

DAS  
16  
2-3 17/10/13

Quality Control

135

Pressure Wash per QSI005 4.3

0.00

**\*135\***

HandFinish

Memo

0.00

1 16 12/10/15

Hand Finishing

140

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00

**\*140\***

Powdercoat

Memo

0.00

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

9:00  
400 F  
9:30

IX  $\phi$  12/10/16

M122878

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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# Work Order ID 86295

**\*86295\***

Page 3

June-26-12 3:38:30 PM

Item ID: D2330-043

Accept

**\*N900040100\***

Setup Start **\*NS1\***

Revision ID:

Stop **\*NS2\***

Item Name: Basket Lid Assembly

Start Date: 26/06/2012 Start Qty: 1.00

**\*1\***

Cust Item ID:

Required Date: 10/07/2012 Req'd Qty: 1.00

**\*1\***

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start **\*NR1\***

QC:

Date:

SPC (Y/N):

Date:

Stop **\*NR2\***

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

150

QC3- Inspect Part Finish

0.00

**\*150\***

QC

Memo

0.00

Quality Control

1  $\phi$  12-10-16

160

Identify as per dwg & Stock Location: *D206-54-013.*

0.00

*86289*

**\*160\***

Packaging

Memo

0.00

Packaging

1  $\phi$  12-10-16

170

QC21- Final Inspection - Work Order Release

0.00

**\*170\***

QC

Memo

0.00

Quality Control

12/10/18

*12-10-17*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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**NOTE:** Date & initial all entries

# Picklist Print

June-26-12 3:38:34 PM

Page 1

Work Order ID: 86295

**\*86295\***

Parent Item: D2330-043

**\*D2330-043\***

Parent Item Name: Basket Lid Assembly

Start Date: 26/06/2012

Required Date: 10/07/2012

Start Qty: 1.00

Required Qty: 1.00

## Comments:

IPP Rev:H 02.09.04 M304EX0.75-16F was M750-16FXS-S/S KJ

IPP Rev:I 08-09-09 revF as per dwg (ecn 08-522) DD verf:EC

IPP REV:J 10.11.30 AS PER DWG REV.H DD VERF:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
✓ D2252-1 *D2252-1* Frame		Manufactured	No			100	Each	0.0000	2	2			
									**	B91047-2		PD 12-10-03	
✓ D2252-7 *D2252-7* Frame		Manufactured	No			100	Each	3.0000	4	4			
									**	B86853-4		PD 12-10-03	

Location	Loc Qty	Loc Code
WA	1	
83978	1	
WA006	2	
73201	2	

✓ D2327-3  
\*D2327-3\*  
Spacer Bushing

Manufactured No 100 Each 30.0000 1 1

\*\*

12-10-03 PD

Location	Loc Qty	Loc Code
WA	26	
82325	26	
WA005	4	
75564	1	
77229	1	
81144	2	

B88561-1

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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June-26-12 3:38:34 PM

Page 2

Work Order ID: 86295

**\*86295\***

Parent Item: D2330-043

**\*D2330-043\***

Parent Item Name: Basket Lid Assembly

Start Date: 26/06/2012

Required Date: 10/07/2012

Start Qty: 1.00

Required Qty: 1.00

D2329

Manufactured No

100

Each

4.0000

1

1

**\*D2329\***

Label Plate

\*\*

12-10-03 PD

## Location

## Loc Qty

## Loc Code

WA

3

84714

3

WA006

1

40488

1

B79357 -> ①

D2330-1

Manufactured No

100

Each

0.0000

2

2

**\*D2330-1\***

Frame

\*\*

B91049 -> ② 12-10-03 PD

D2330-15

Manufactured No

100

Each

0.0000

1

1

**\*D2330-15\***

Frame

\*\*

B91051 ① 12-10-03 PD

D2581

Manufactured No

100

Each

79.0000

2

2

**\*D2581\***

Mounting Bracket

\*\*

12-10-03 PD

## Location

## Loc Qty

## Loc Code

WA

49

82506

2

83230

3

85436

20

85452

24

WA005

30

70766

2

81253

1

82897

27

B86961 -> ②

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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Page 3

Work Order ID: 86295

Parent Item: D2330-043

Parent Item Name: Basket Lid Assembly

\*86295\*

\*D2330-043\*

Start Date: 26/06/2012

Required Date: 10/07/2012

Start Qty: 1.00

Required Qty: 1.00

✓ D3749-1  
\*D3749-1\*  
Hinge Half

Manufactured No

100

Each

9.0000

3

3

\*\*

12-10-03 PD

## Location

## Loc Qty

## Loc Code

WA005

9

70063

9

100

sf

849.3859

18.9

③

18.9

\*\*

PD 12-10-03

✓ M304EX0.75-16F  
\*M304EX0 75-16F\*  
Expanded Metal Flat SS

Purchased

No

## Location

## Loc Qty

## Loc Code

WA

4.9094

121738

4.9094

WA035

844.4764637

117197

102.9036

120917

101.57273

121521

0.00013372

122080

320

122138

320

M122604 → 18.9

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

ITEM	QTY -041	QTY -043	PART NUMBER	DESCRIPTION
1	X		D2330-041	BASKET ASSEMBLY
3		X	D2330-043	LID ASSEMBLY
7	1		D2012-107	CLEVIS
8	4		D2235-1	RIB
9	2	2	D2252-1	FRAME
10	1	4	D2252-7	FRAME
11	2		D2253-1	LUG
12	2		D2254	GUSSET
13	1	1	D2327-3	BUSHING
14		1	D2329	LABEL PLATE
15	2	2	D2330-1	FRAME
16	1		D2330-5	FRAME
17	1		D2330-7	FRAME
18		1	D2330-15	FRAME
19	4	2	D2581	MOUNTING CHANNEL
20	3		D3748-1	HINGE HALF
21		3	D3749-1	HINGE HALF

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 86295 MCT  
12/06/26

RELEASED  
2010-11-25

**NOTES:**

- 1) FRAME MATERIAL: AISI 304/316 SS, 3/4 x 3/4 x 0.065 WALL SQUARE TUBING  
REF. DART SPEC M304TS0.750W.065
- 2) MESH MATERIAL: 3/4-16F EXPANDED SS  
REF DART SPEC M304EX0.75-16F
- 3) FINISH: POWDER COAT ASSEMBLY GLOSS WHITE (4.3.5.2) PER DART QSI 005 4.3
- 4) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) UNITS: INCHES UNLESS OTHERWISE NOTED
- 6) BREAK SHARP EDGES: N/A
- 7) IDENTIFICATION: N/A
- 8) WEIGHT: N/A
- 9) WELDING: PER DART QSI 004

H	DIM 0.50 WAS 0.75 (ZN D2-3 & D6-3) REF NCR 10-346	JPH	10.09.28
G	ADDED 'ITEM' COLUMN TO PARTS LIST; ADDED NOTE 10 ON SHT 2; ITEMS 20 AND 21 REPLACE D2232-1/-3; STRETCHED LID FROM 83.27" TO 84.00"; ITEMS 9 & 10 REPLACE D2330-3/-9/-13; ITEM 13 (ON LID) REPLACES D2327-1; REORGANIZED ALL SECTION & DETAIL VIEWS. REASON: SEE PAR#09-006.	MB	09.02.05
F	DRAWING UPDATED TO CURRENT STANDARDS. SHEET 6 ADDED. FRAME MATERIAL THICKNESS WAS 0.060.	AJS	08.08.11
E	INCORPORATED D1. D2253-1 WAS D2253 (NCR 533).	KE	05.11.10
D	MODIFIED LATCH, REDRAWN	KE	99.09.14
C	ADDED LATCH AND LABEL PLATE	BK	96.05.23
REV.	DESCRIPTION	BY	DATE
DESIGN	JB	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	J		
CHECKED	J	DRAWING NO.	REV. H
MFG. APPR.	J	D2330	SHEET 1 OF 6
APPROVED	J	TITLE	SCALE
DE APPR.	J	BASKET ASSEMBLY (206B)	NTS
DATE	10.09.28	COPYRIGHT © 1994 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSES OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

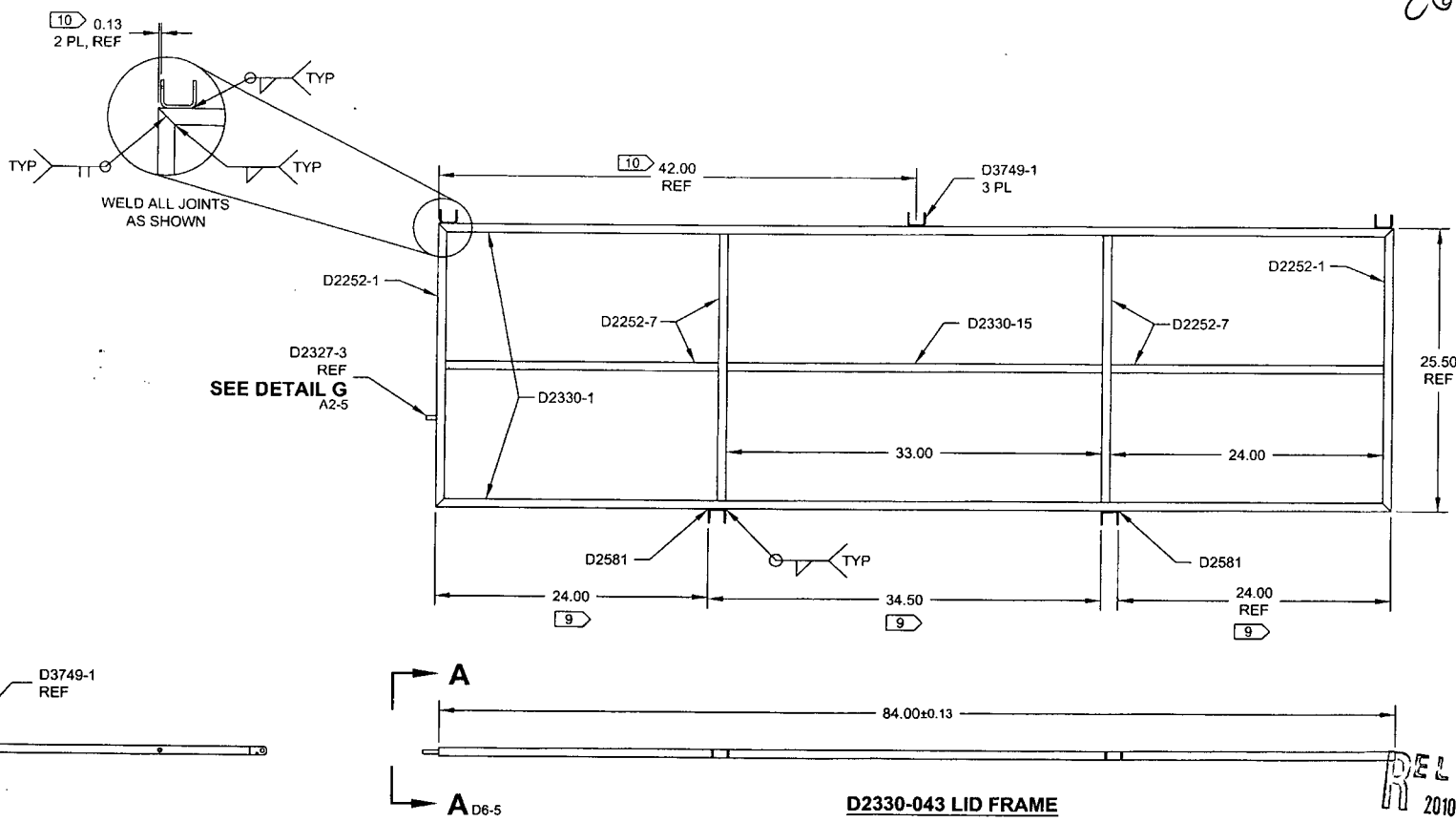
Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

86295



**LID FRAME NOTES:**

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: N/A
- 8) WELDING: PER DART QSI 004
- 9) ALIGN WITH ADJACENT D2581 ON BASE
- 10) CENTER D3749-1 HINGE HALF ON D3748-1 HINGE HALF LOCATED ON D2330-041 BASKET BASE ASSEMBLY

**D2330-043 LID FRAME**

RELEASED  
2010-11-25

DESIGN	JB	<b>DART AEROSPACE LTD</b>	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. H
MFG. APPR.		D2330	SHEET 2 OF 6
APPROVED		TITLE	SCALE
DE APPR.		BASKET ASSEMBLY (206B)	NTS
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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

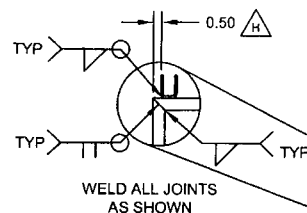
Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

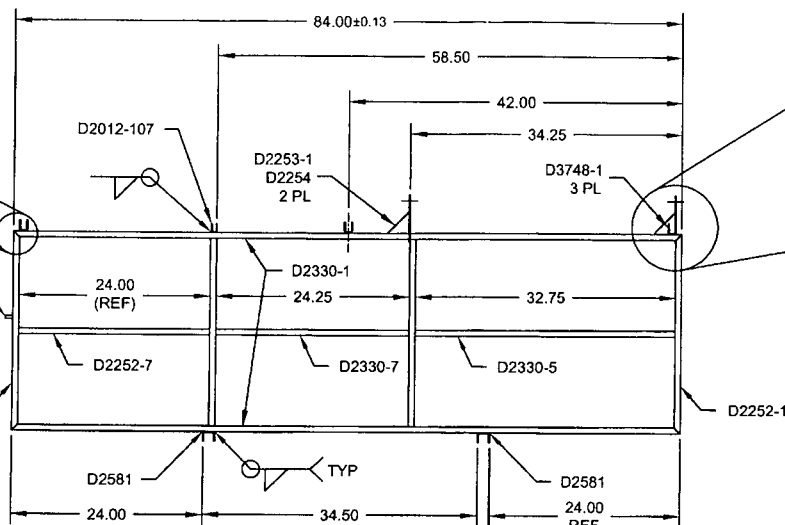
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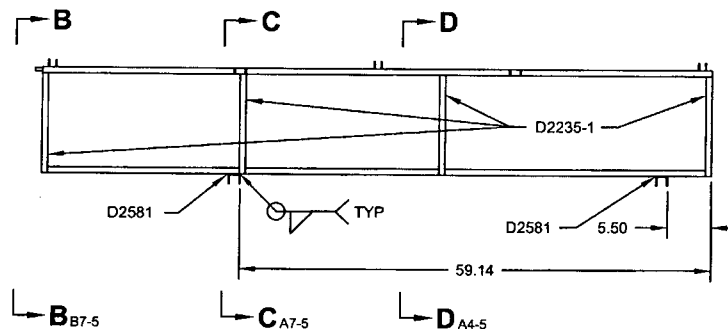
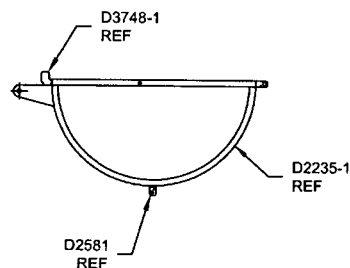




D2327-3  
REF  
SEE DETAIL G  
A2-5



86295



# **D2330-041 BASE FRAME ASSEMBLY**

## **BASE FRAME NOTES:**

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: N/A
- 8) WELDING: PER DART QSI 004

DESIGN	JB	<b>DART AEROSPACE LTD</b>	
DRAWN	For JPH	HAWKESBURY, ONTARIO, CANADA	
CHECKED	UP	DRAWING NO.	REV. H
MFG. APPR.	N	D2330	SHEET 3 OF 6
APPROVED		TITLE	SCALE
DE APPR.		BASKET ASSEMBLY (206B)	NTS
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RELEASE  
2010-11-25

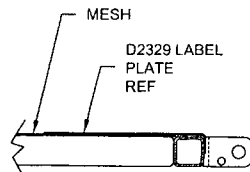
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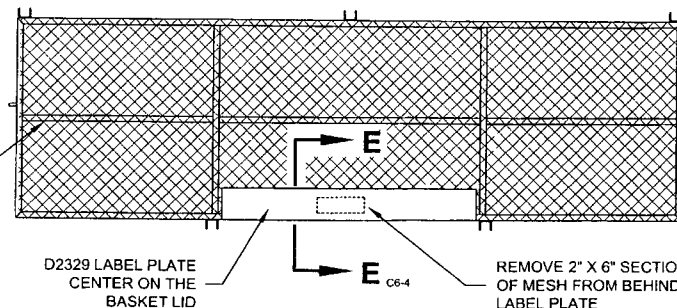
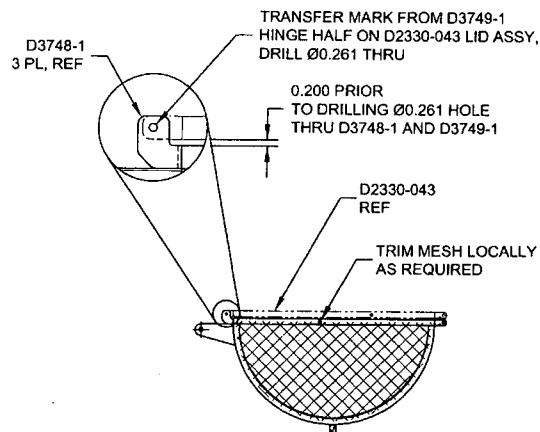
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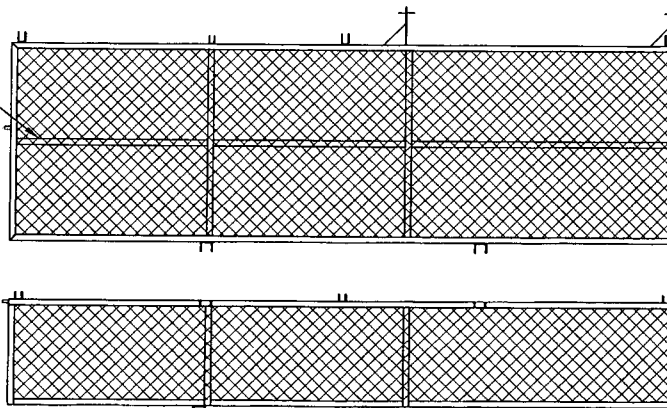


**SECTION E-E** C3-4  
VIEW ROTATED 90° CCW

TACK WELD EACH  
STRAND END OF  
MESH TO FRAME



**D2330-043 LID ASSEMBLY**



**D2330-041 BASE ASSEMBLY**

**ASSEMBLY NOTES:**

- 1) MATERIAL: SEE SHEET 1 FOR MESH MATERIAL
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: N/A
- 8) WELDING: PER DART QSI 004

DESIGN	JB	<b>DART AEROSPACE LTD</b>	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. H
MFG. APPR.		D2330	SHEET 4 OF 6
APPROVED		TITLE	SCALE
DE APPR.		BASKET ASSEMBLY (206B)	NTS
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RELEASED  
2010-11-25

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

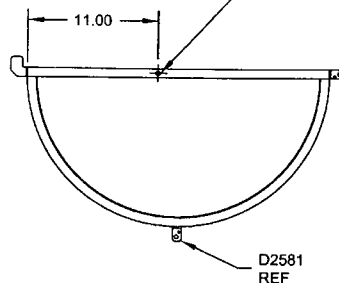
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

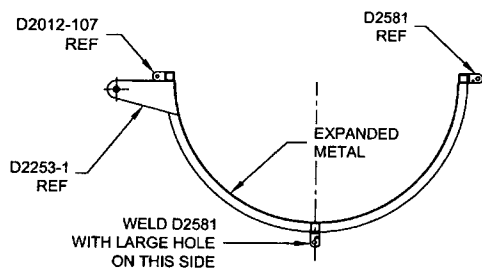


**VIEW A-A** A6-2

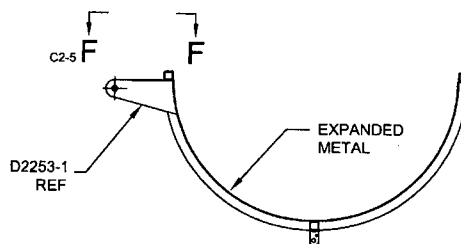
DRILL 3/8 HOLE AND  
INSTALL D2327-3  
SEE DETAIL G A2-5



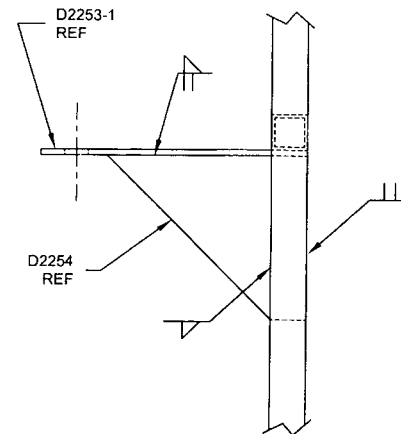
**VIEW B-B** A5-3



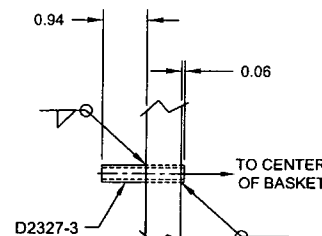
**SECTION C-C** A4-3



**SECTION D-D** A3-3



**VIEW F-F** B6-5  
SCALE 4X



**DETAIL G**  
SPACER INSTALLATION  
SCALE 4X

RELEASED  
2010-11-25

DESIGN	JB	<b>DART AEROSPACE LTD</b>	
DRAWN	A. F. J. P. H.	HAWKESBURY, ONTARIO, CANADA	
CHECKED	JP	DRAWING NO.	REV. H
MFG. APPR.	JP	D2330	SHEET 5 OF 6
APPROVED	JP	TITLE	SCALE
DE APPR.	JP	BASKET ASSEMBLY (206B)	NTS
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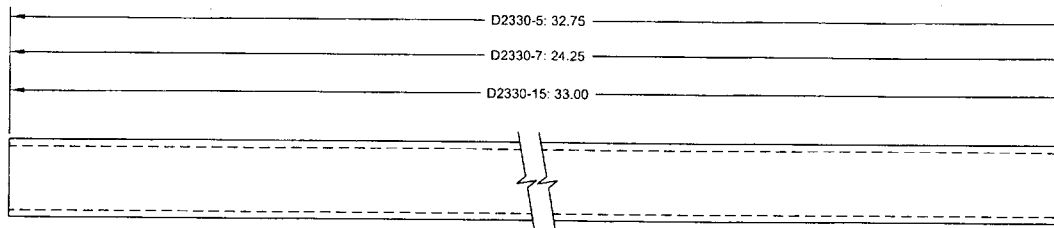
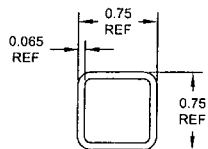
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

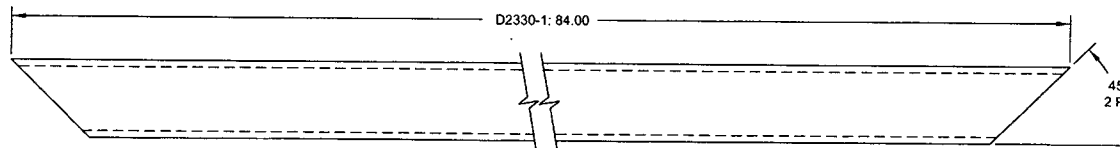
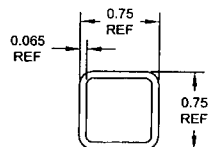
Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



D2330-5 FRAME  
D2330-7 FRAME  
D2330-15 FRAME



D2330-1 FRAME

**NOTES:**

- 1) FRAME MATERIAL: SEE SHEET 1
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: N/A

DESIGN	JB	<b>DART AEROSPACE LTD</b>	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. H
MFG. APPR.		D2330	SHEET 6 OF 6
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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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**NOTE:** Date & initial all entries